



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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RBW6005G01831-3G-PO

Job Sheet 198905



Part No: RBW6005G01831-3G-PO **Job Qty:** 3 pcs

Part Name: Dial Indicator Tail Rotor Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 10/4/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6005G01831-3G Rev.3 IPP Rev. A 19.02.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	3 pcs	10/4/19	10/4/19	0.00	0.00	Purchasing - 1	DP 27 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	3 pcs	10/4/19	10/4/19	0.00	0.00	Packaging 2 - 1 - B4B	DP 27 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
120	QC 6	3 pcs	10/4/19	10/4/19	0.00	0.00	QC 6 - 9	
							QC 6 - 68	DAS
							QC 6 - 61	61
							QC 6 - 40	9-89
							QC 6 - 81	
130	Packaging 3-1 - Stock - B4B	3 pcs	10/4/19	10/4/19	0.00	0.00	Packaging 3 - 1 - B4B	DAS
							Packaging 3 - 2 - B4B	28
							Packaging 3 - 3 - B4B	9-89
							Packaging 3 - 4 - B4B	
							Packaging 3 - 5 - B4B	
140	QC 21 - SA	3 pcs	10/4/19	10/4/19	0.00	0.00	QC 21 - SA - 21	DAS
							QC 21 - SA - 70	21 OCT 03 2019

Part Op 100 - -Issue P/O to ARROW TECH MACHINE WORKS ; P/O HB04422-1 -Manufacture RBW6005G01831-3G as
Descriptions: per DWG. -Certificate of Conformity is required
110 - Certificate of Conformity is required
120 - QC6- All purchased or subcontracted products
130 - Identify as per dwg & Stock Location: _____
140 - QC21- Final Inspection - Work Order Release

x 3 plus

Job BOM

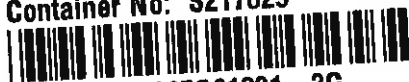
Part / Item	Component Name	Quantity	Operation	Container
RBW6005G01831-3Gp	Dial Indicator Tail Rotor Support	3 pcs (1 ea)	100-Purchasing	5217816

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6005G01831-3Gp	3	0	0
Part Specifications				
Specifications could not be found.				

Plex 8/7/19 12:30 PM dart.lussier.patrick



Container No: S217829



Part: RBW6005G01831-3G

Job No: 198905

Serial No/Batch: S217829

Revision: 3

Inspector:

Exp Date:

Instructions:

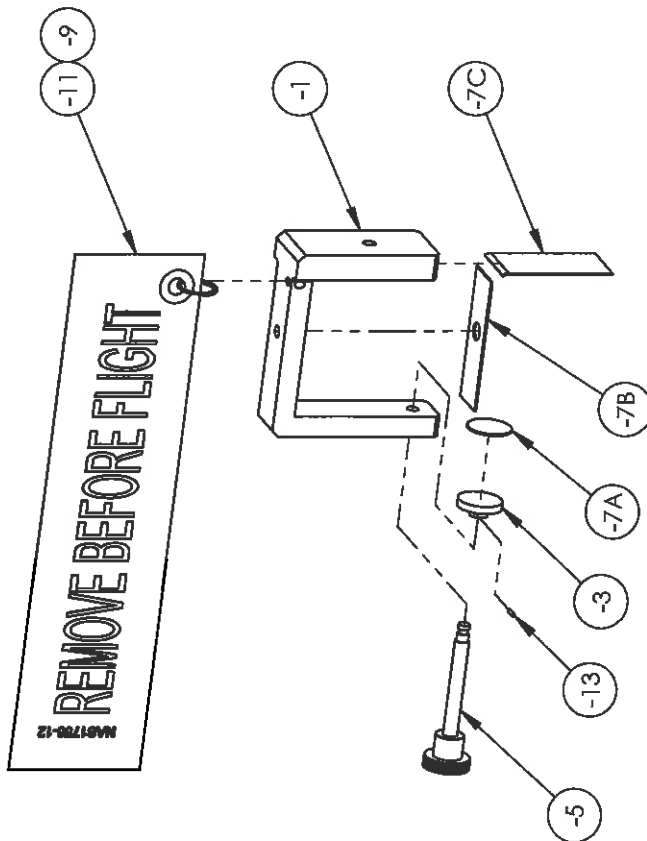
Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/27/19

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REVISIONS

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REPLACED THUMB NUT, ALL THREAD & DOWEL PIN WITH THUMB SCREW & ROLL PIN.	3/20/2009	WP	DW
1A		CHD ENGRAVE NOTE P/N -1.	5/28/2009	RJC	RW
2		CORRECTED DIM P/N -1 FROM .513 TO .482 DIM SNAPPED TO DIM EXT. NOT CORNER, CHD P/N -11 FROM MAST 756-18, CHD P/N -1 RADIUS FROM .250, ADDED MISSING R.125 DIM P/N -1 TOP VIEW, & .119 DIM SIDE VIEW.	10/14/2009	RJC	RW
2A		CHD TITLE WAS SUPPORT, DIAL INDICATOR TAIL ROTOR ASSEMBLY IS SUPPORT ASSY, DIAL GAUGE (T/R DAMPER BLADE SIDE), -13 ADDED B/O P/N INFO, -1, -3, -5 MOVED TO SEPARATE SHEETS, -3.	4/15/2014	DPD	JAG
3	16-0224	UPDATED TO NEW STANDARD, -1 CHD DIMS WAS .592 IS 2X .592, WAS 2X R.125 IS 2X R.13, WAS .188 IS .19, WAS .200 IS .20, WAS .312 IS R.31, WAS R.312 IS R.31, WAS 2X R.030 IS 2X R.03, ADDED DIM 2.66, -3 CHD DIMS WAS .0980 IS .098, WAS .0393 IS .039, WAS .0362-.065 IS .0362-.065 (P.F. -13), -5 CHD DIMS WAS 3.31 IS (3.31), WAS 3.06 IS (3.06), WAS .0100 MED KNURL IS (.0100), WAS .625 IS (.625), WAS 5/16-18 UNC IS (5/16-18 UNC), -7 DELETED FROM BOM, -7A, -7B, -7C ADDED TO BOM & DRAWING, -13 CHD B/O REF WAS #90145A416 IS #92373A106.	11/17/2016	DPD	JAG



NOTES:

- REFERENCE:
RBW6005G01831 = 3G6005G01831
RBW6005G01831-1 = 3G6005G04131
RBW6005G01831-11 = 999-3900-17-3
- FUNCTION:
USED TO INSPECT FOR PLAY (AXIAL) OF THE T/R SPHERICAL BEARINGS (T/R BLADE SIDE), WITHOUT REMOVING THE COMPONENTS FROM THE AIRCRAFT.



TITLE SUPPORT ASSY, DIAL GAUGE
(T/R DAMPER BLADE SIDE)

DWG NO. RBW6005G01831-3C

REV 3

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
FRACTIONS $\pm 1/8$
XXX $\pm .005$
XX $\pm .01$
X $\pm .1$
ANGLES $\pm .5^\circ$
SURFACES $\pm .125$
1. BREAK ALL SHARP EDGES
.015 x 45° OR .018
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009
USED ON MODEL
AW139

ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		-1	1	CLAMP FRAME	304 S.S.		2
		-3	1	SWIVEL END	304 S.S.		3
		-5	1	THUMB SCREW	S.S.	5/16-18 X 3.01 (MCMASTER-CARR #6091K47) MODIFIED	4
		-7A	1	PAD MATERIAL WITH ADHESIVE BACK	NEOPRENE	.036 THICK, DUROMETER 60A (GASKET SPECIALTIES) MODIFIED	5
		-7B	1	PAD MATERIAL WITH ADHESIVE BACK	NEOPRENE	.036 THICK, DUROMETER 60A (GASKET SPECIALTIES) MODIFIED	6
		-7C	1	PAD MATERIAL WITH ADHESIVE BACK	NEOPRENE	.036 THICK, DUROMETER 60A (GASKET SPECIALTIES) MODIFIED	7
	B/O	-9	1	SPLIT RING	STEEL	Ø7/8 O.D. X 1/8 (MCMASTER-CARR #90177A217)	1
	B/O	-11	1	REMOVE BEFORE FLIGHT	NYLON	NAS 1756-12	1
	B/O	-13	1	ROLL PIN	S.S.	Ø1/16 X 5/16 (MCMASTER-CARR #92373A106)	1

SCALE 1:4

DATE 1/30/2009

AW139

SHEET 1 OF 7



Dart Aerospace Ltd.
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Tel (613) 632-5200

PURCHASE ORDER POHB044221



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

Attention: , Ana
(541) 780-6938

Ship To:

PO No: POHB044221

PO Date: 8/7/19

Due Date: 10/4/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	198905	RBW6005G01831-3Gp			Dial Indicator Tail Rotor Support REV 3	Firmed	-	10/4/19	3 pcs	0 pcs	3 pcs	\$1,141.25/pcs	\$3,423.75
2	198908	RBW6005G00531-3GP			Jack Screw REV 2	Firmed	-	10/4/19	6 Ea	0 Ea	6 Ea	\$133.00/Ea	\$798.00
3	198909	RBW6005G00631-3GP			Jack Screw REV 2	Firmed	-	10/4/19	6 Ea	0 Ea	6 Ea	\$133.00/Ea	\$798.00
4	198911	RBW6205G00432-3Gp			Main Rotor Pitch Control Link Adjustment Tool REV 5	Firmed	-	10/4/19	3 pcs	0 pcs	3 pcs	\$2,030.50/pcs	\$6,091.50
5	198912	RBW6305G00232-3GP			Gimbal Torque Tube Bushing Installer REV 2	Firmed	-	10/4/19	2 Ea	0 Ea	2 Ea	\$708.75/Ea	\$1,417.50
Grand Total:												\$12,528.75	



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PURCHASE ORDER
POHB044221



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

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ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044221

Dated: 9/20/2019

Our Order / Job No: AWT-HB044221 A1

Order Qty: 3

Part Name: SUPPORT ASSY, DIAL GUAGE (T/R DAMPER BLADESIDE)

Part Number RBW6005G01831-3G

Lot Size: N/A

Ship Date: 9/20/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6005G01831-3G

Rev: 3

DAS
61
9-88

Material Size and Type: -1, -3/ 304 S.S.

Material Specifications: S.S.: ASTM A511

Heat Treatment: N/A

Plating/Finish: N/A

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date:

9/20/19

Signed:

Hernan M. Falt

PHGE Machine Works LLC dba Arrow Tech Machine Works
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